

Work Order ID 128109

128109

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January-07-15 9:04:04 AM

Item ID: D2792-130 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: EXTRUSION
 Start Date: 1/07/15 Start Qty: 50.00 ***50*** Cust Item ID:
 Required Date: 1/30/15 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2792	Rev A1

100	PURCHASING	0.00
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100

Purchasing
 Purchasing

Memo

Issue P/O: 26974

a) Extrude as per Dwg D2792

b) Material: 6061-T6 (QQ-A-200/8)

c) Tool: MS-19248

d) Material certification is required.

e) 130 is equal to 130.0"

EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.

MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE

CL 15/01/08 52

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Item ID: D2792-130 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: EXTRUSION
 Start Date: 1/07/15 Start Qty: 50.00 ***50*** Cust Item ID:
 Required Date: 1/30/15 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.00							
Packaging	Ensure material certification and pull test results attached								

52x 8015-02-6

120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control	Check pull test Report to Dwg D2792 for compliance								

(52) 15-03-13 DAS 9 9-8E

130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							
Packaging									

52 15-3-14

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Item ID:	D2792-130	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:					Stop	*NS2*
Item Name:	EXTRUSION					
Start Date:	1/07/15	Start Qty: 50.00	*50*	Cust Item ID:		
Required Date:	1/30/15	Req'd Qty: 50.00	*50*	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MLJ 150320
MLJ 150320

Picklist Print

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Work Order ID: 128109

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Parent Item: D2792-130

D2792-130

Parent Item Name: EXTRUSION

Start Date: 1/07/15

Required Date: 1/30/15

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP A98.11.09New IssueKS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2792-130P

Purchased

No

100

Each

0.0000

1

50

D2792-130P

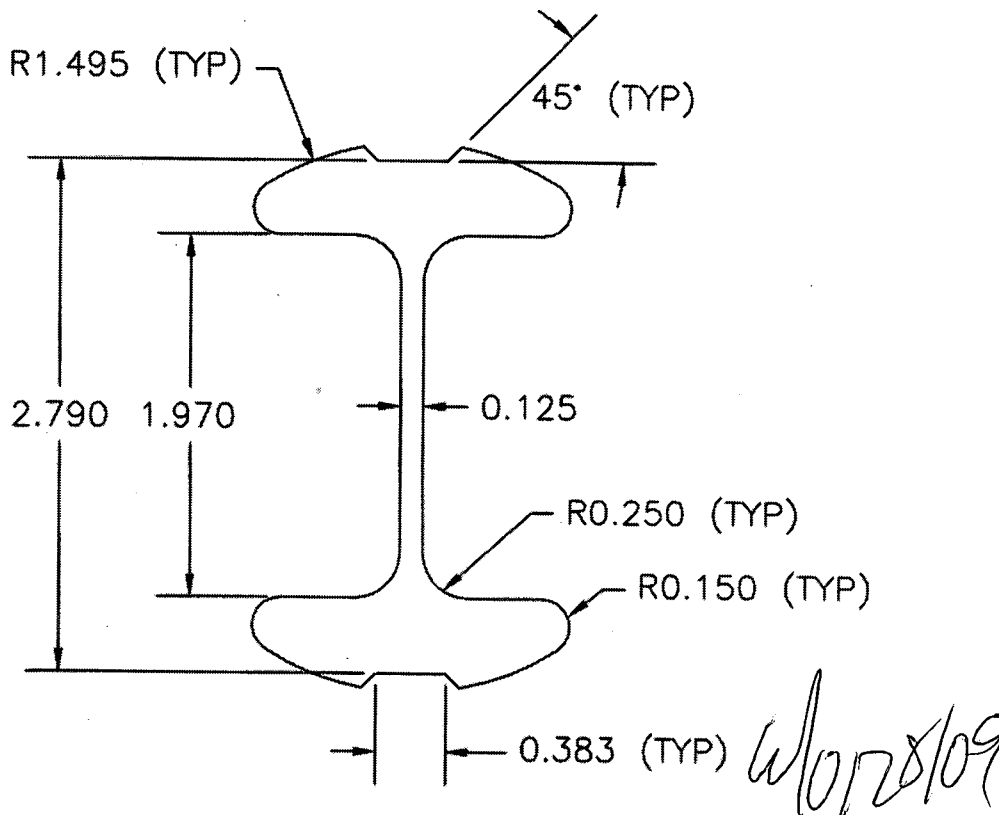
Extrusion

52x 8p15-02-6



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2792	REV. A SHEET 1 OF 1
DATE 98.08.13		TITLE EXTRUSION	SCALE 1:1
A	98.08.13	NEW ISSUE	
A1	01.04.17	ADD NOTE *7 <i>4 UP</i>	

RELEASED
98.08.25 BS



GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/B)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES

2. MANUFACTURED USING CARADON INDALEX DIE # MS-19248
3. BREAK ALL SHARP CORNERS 0.010 MAX.
4. NO ID TOOLING MARKS.
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
6. ALL DIMENSIONS ARE IN INCHES.
7. PART NUMBER IS D2792-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2792-145 IS 145" LONG)

325 rue Avro
Pointe-Claire, QC, Canada H9R 5W3
Téléphone (514) 697-5120
Fac-simile (514) 694-8310

sapa:

Rapport des propriétés mécaniques Mechanical Properties Test Report

Client / Customer : **DART AEROSPACE LTD**

Adresse / Address : **1270 ABERDEEN STREET
HAWKESBURY ONT,
K6A 1K7**

Commande Sapa / Sapa order # : **5010339**

Bon de commande / Purchase order # : **26974**

Matrice / Die # : **MS 19248**

Description : **"I" SUPPORT COMPONENT**

Alliage & trempage / Alloy & temper : **6061 T6**

Customer Part # : **D2792**

Contrôle / Control # : **35652-1**

Coulée / Cast # : **61933**

	Min.requis Min.required	Résultat actuel Actual results
Tension ultime Ultimate stress (psi)	38 000	45 170
Contrainte élastique Yield stress (psi)	35 000	40 388
% élongation dans 2" % elongation in 2"	8	9.12
Dureté Rockwell E (hre) Rockwell E Hardness (hre)	88 @ 100	94

Composition chimique typique / Typical chemical composition :

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti
6063	0,20 - 0,60	0,35 Max	0,10 Max	0,10 Max	0,45 - 0,90	0,10 Max	0,10 Max	0,10 Max
6005	0,60 - 0,90	0,35 Max	0,10 Max	0,10 Max	0,40 - 0,60	0,10 Max	0,10 Max	0,10 Max
6005A	0,68 - 0,72	0,15 - 0,27	0,08 - 0,12	0,20 - 0,24	0,48 - 0,52	0,03 Max	0,05 Max	0,03 Max
6061	0,40 - 0,80	0,70 Max	0,15 - 0,40	0,15 Max	0,80 - 1,20	0,04 - 0,35	0,25 Max	0,15 Max
6351	0,7 - 1,3	0,5 Max	0,10 Max	0,40 - 0,80	0,40 - 0,80	---	0,20 Max	0,20 Max

Nous certifions que le matériel fourni rencontre les exigences chimiques telles qu'annoncées par la norme ASTM B-221-08 excepté pour la section 8.2 (nombre de spécimen) .

We hereby certify that the material supplied meets the chemical properties as published by the ASTM B-221-08 except for section 8.2 (number of specimen) .

Sincèrement vôtre,
Yours truly,

date : **2015-01-29**



Gilles Pelletier
Technicien de la qualité
Quality technician



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO26974

Purchase Order Date 1/8/2015

PO Print Date 1/8/2015

Page Number 1 of 2

Order From :

VC-SAP001

Ship To : DART AEROSPACE LTD

SAPA CANADA INC
C/O 912420
P.O. BOX 4090 STN A
TORONTO, ONTARIO M5W OE9
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 800 563 5120

Ship To Contact

Ship To Phone

Ship Via: Yours ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2792-130P	Extrusion	2/6/2015 Yes 2/6/2015		52.00 Each	\$53.56	\$2,785.00
EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES NICKS OR DENTS AS PER DWG D2792 REV. A B128109 MATERIAL: 6061-T6 AS PER QQ-A-200/8 OR AMS-QQ-A-200/8 OR ASTM B221 CUT TO LENGHT 130" LONG DIE # MS-19248							

SP15-02-6

Line Total:

\$2,785.00

(USE ALERT IT) !

Note:

1/8/2015

sapa:

Adresse Postale: Sapa Canada, Inc
325, rue Avro
Pointe-Claire Québec H9R 5W3
Téléphone: (514) 697-5120
Télécopieur: (514) 694-8310

Packing Slip / Détail de Livraison

Packing Slip No /
Bon de Livraison 13549

Order no/
Commande 5010339 1

Ship to/Expédié à DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ONT K6A1K7				Sold to/Vendu à DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ONT K6A1K7				Special Instr / Instr. Spéciales				
Cust No/No du Client 201355		Cust No/No PO du Client 26974		PPD/PAYÉ X	Ord Dte/Dte Comm 15/01/09		Our Ord Dte/ Notre Dte la Comm 15/01/09		Sapa G.S.T #: R857314058			
PST/TPV *6122-5207			Terms/Cond		Date Required/ Date Requête		Shipped/ Expédiée 15/02/04		Shipped Via/ Expédiée Par OTTAWA 5 FEB			
Item No	Ordered Weight Pcs/ Commande Poids Pcs	Sapa Die no/ Matrice d'Sapa	Customer Description/ Description de Client	Alloy & Temper/ Alliage et Trempage	Length Longueur	Backorder Wgt Pcs Arrière Poids Pcs	This Shipment Bdls Wgt Pcs Com Expédiée Ballots Poids Pcs					
1	500 52	MS 19248 D2792	6061 T6 3302		N	1	544	57	POIDS EN KGS			
DUE=2015/02/06 FE06NS "I" SUPPORT COMPONENT BUNDLE= 1170084 We hereby certify that the material supplied meets the chemical properties as published by the Aluminum Association, and requirements of our Quality procedures <i>SP 15-02-06</i>												

Aluminum Extrusions - Anodizing - Fabrication - Painting
Profils D'Aluminum - Anodisation - Fabrication - Peinture

The above items were received in good order.
Les articles ci-dessus ont été reçus en bon ordre.

By/Par.....